

# Work Order ID 95576

Monday, January 14, 2013 1:45:39 PM

**\*95576\***

Page 1

Item ID: D4537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Flat Window, LH  
 Start Date: 1/14/2013 Start Qty: 1.00 **\*1\*** 2 Cust Item ID:  
 Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\*** 2 Customer:  
 Reference:

Approvals: Process Plan: PA Date: 13-01-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4537	PA2								
100		0.00							
<b>*100*</b>	HAND FINISHING THERMOFORMING								
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Set up Machine as per folio FTA 138 and DXXXX program								DAS 07 13/1/15
110		0.00							
<b>*110*</b>	HAND FINISHING THERMOFORMING								
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Cut Blanks 38" X 52"								DAS 07 13/1/15
120		0.00							
<b>*120*</b>	THERMOFORMING MACHINE								
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4537-1 and Folio FTA138								
	Rev. <u>A</u> Folio Rev. <u>A</u>								
	Visually inspect for proper formation and clarity								DAS 07 13/1/15

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Start Date: 1/14/2013 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	HAND FINISHING THERMOFORMING	0.00							
<b>*150*</b> Thermoform Thermoforming Machine	Memo 1) Trim off excess flange material 2) Buff out any light scratches or blemishes 3) Etch part number and batch number	0.00				2			B 13/01/22
160	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*160*</b> QC Quality Control	Memo	0.00				2			DAS 21 2-89
170	QC5- Inspect part completeness to step on W/O	0.00							
<b>*170*</b> QC Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00							DAS 16 2-89 13/1/24

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Item ID: D4537-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Flat Window, LH

Start Date: 1/14/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
<b>*180*</b>									
Packaging	Memo	0.00				2			BB 13/01/24
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							13/1/28 DJ
Quality Control									

PLB-01-25

# Picklist Print

Monday, January 14, 2013 1:45:44 PM

Page 1

Work Order ID: 95576

\*95576\*

Parent Item: D4537-1

\*D4537-1\*

Parent Item Name: Flat Window, LH

Start Date: 1/14/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 12.01.11 new issue EC verified by:DD  
12/02/09 thermoform w/extension DL verf:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRYLICS.177

Purchased

No

100

sf

346.6600

13

13.68421

**\*MACRYLICS 177\***

\*\*

0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SHEET

Location

Loc Qty

Loc Code

therm

346.66

119505

14.66

120972

44

122537

288

~~13.68~~ 13/01/21  
27.36

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 9ss76
<b>Description:</b> FLAT WINDOW		<b>Part Number:</b> D4537.1
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> <i>JB</i>	<b>Date:</b> 13/01/15
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**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.1	.100	29.125	✓		PTH-05	
46.0	.100	46.06	✓		TH-05	
.090	.030	.164	✓		PRO-W-3.01	

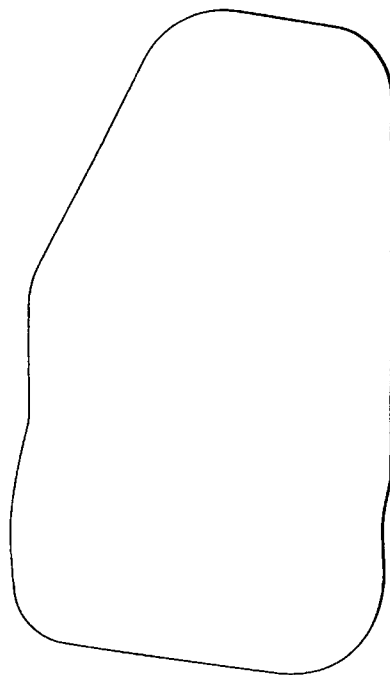
<b>Measured by:</b> <i>JB</i>	<b>Date:</b> 13/01/23
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<b>Audited by:</b> <i>S 13/1/25</i>	<b>Date:</b>
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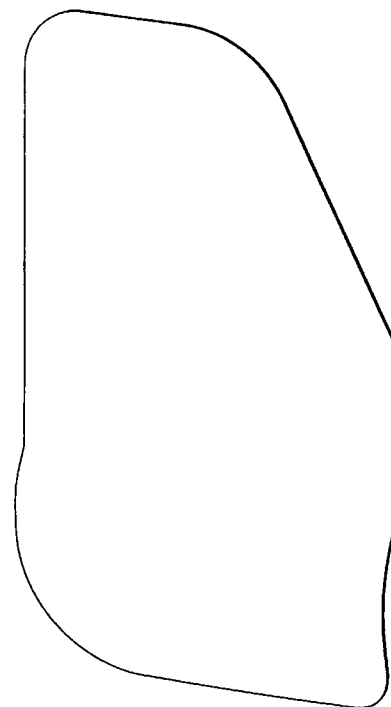
<b>Preliminary Approval:</b>	<b>Date:</b>
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*10.04.14*



**D4537-1 FLAT WINDOW (LH)**

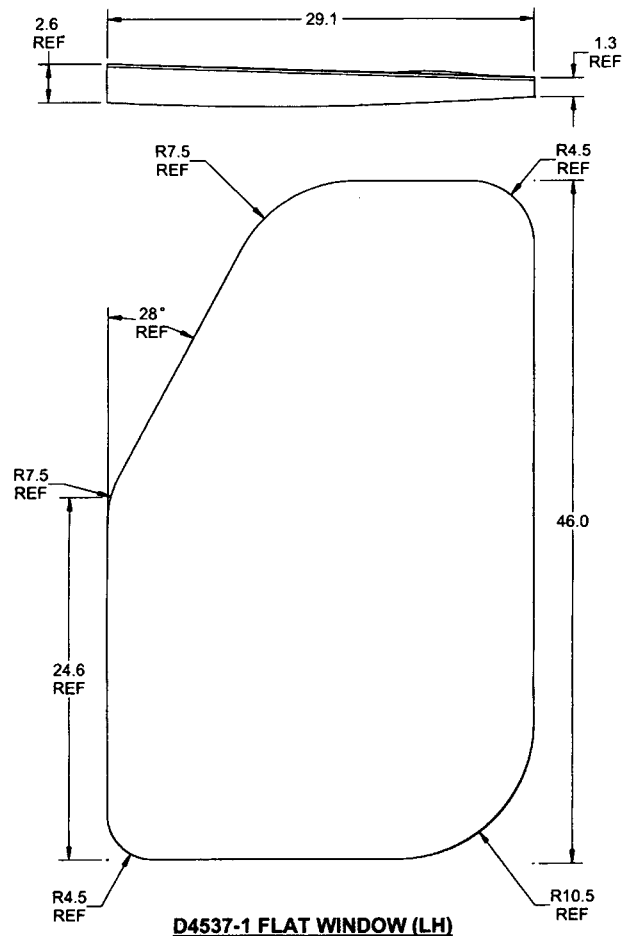


**D4537-2 FLAT WINDOW (RH)**

95574  
P113-01-14

**RELEASED**  
2012-03-08  
MB

A		NEW ISSUE		AP	12.02.27
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4537</b> TITLE <b>FLAT WINDOW</b>			REV. A
DRAWN	AP				SHEET 1 OF 3
CHECKED	AP				SCALE
MFG. APPR.	AP				NTS
APPROVED	AP				
DE APPR.	AP				
DATE	12.02.27			COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



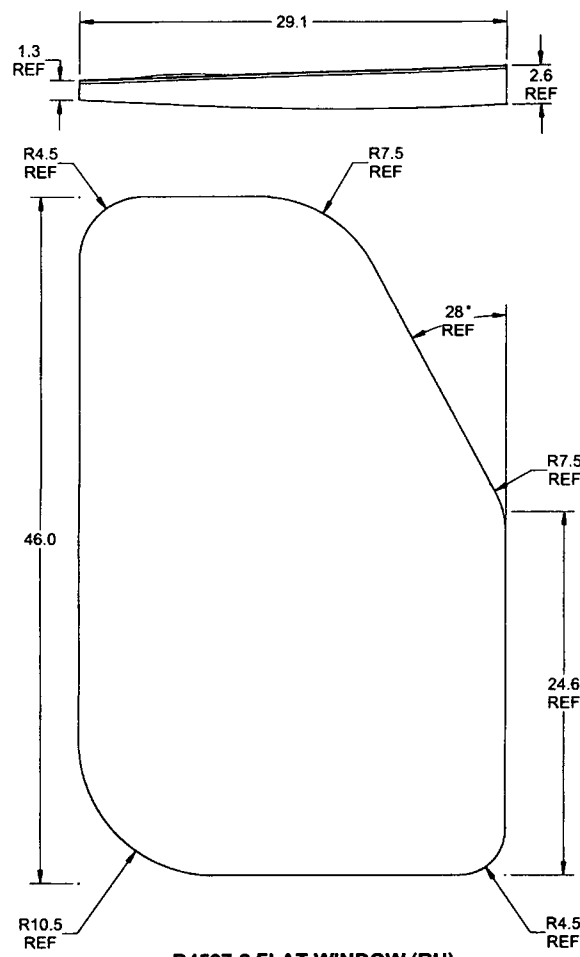
Q5574

RECEIVED  
2012-03-08

# NOTES:

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C  
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
.177 THK (REF. DART SPEC. M-ACRYLIC-S.177)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.80 lbs
- 8) THERMOFORM PER QSI 022 USING DT8992, DT9795, DT9797
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.090"

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4537</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>FLAT WINDOW</b>	NTS
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**D4537-2 FLAT WINDOW (RH)**

95574

**RELEASED**  
2012-03-09

- NOTES:**
- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 .177 THK (REF. DART SPEC. M-ACRYLIC-S.177)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 9.80 lbs
  - 8) THERMOFORM PER QSI 022 USING DT9794, DT9796, DT9798
  - 9) MINIMUM THICKNESS AFTER FORMING IS 0.090"

DESIGN	AP	<b>DART AEROSPACE LTD</b>	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4537</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>FLAT WINDOW</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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